

Date: Thursday, 07/02/2008 10:00:11 AM
 Cdr: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LOW PROFILE BASKET LID ASS'Y
Job Number	: 37287		
Estimate Number	: 13153		
P.O. Number	:	Part Number	: D3713042 <i>W</i>
This Issue	: 07/02/2008 S.O. No. :	Drawing Number	: D3713 U/R
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: U/R
Previous Run	: 37197	Material	:
Written By	:	Due Date	: 14/02/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev'd new issue 08-01-30 DD verified by:		



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 32.5731 f(s)/Unit Total : 32.5731 f(s)
 304 SQ Tube.75x.75x.065W

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

QTY	PART NUMBER	BATCH
2	D3714-1	<i>M106909</i>
2	D3715-1	<i>M106909</i>
10	D3716-1	<i>M106909</i>
4	D3732-1	<i>M106909</i>

2- Deburr

Plc 08-02-14

2.0	D23271	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer Bushing
 batch *B 36920*

Plc 08-02-14

3.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Mounting Bracket
 batch *B 36481*

Plc 08-02-14

4.0	D37491	HINGE HALF
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
 HINGE HALF
 batch *B37202*

Plc 08-02-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.12.16	5	DIM 29.77 IS 29.69 (LOCATION OF D2581) SPACING BETWEEN D2581 IS 34.43 INSTEAD OF 34.50	CP 08.12.16 PV QS/042	PARTS OK VERIFY FIT OF LID WHEN ASSEMBLING W/ BASE	N/A	CP 08.12.16 PV QS/042	CP 08.12.16 PV QS/042	CP 08.12.16 PV QS/042
08.12.16	3	WIDTH OF LID IS 25.38 INSTEAD OF 25.5	CP 08.12.16 PV QS/042	PARTS OK. VERIFY FIT WHEN ASSEMBLING W/ BASE	N/A	CP 08.12.16 PV QS/042	CP 08.12.16 PV QS/042	CP 08.12.16 PV QS/042
08.12.19	8:0	HINGE HALF 0.125" FROM END OF LID INSTEAD OF FLUSH (BOTH ENDS)	LE 08.12.19	ACCEPTABLE. GOOD HINGE ALIGNMENT	N/A	LE 08.12.19	LE 08.12.19	LE 08.12.19

NOTE: Date & initial all entries

Date: Thursday, 07/02/2008 10:00:11 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 37287

Part Number: D3713041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- drill holes in both D3715-1 as per dwg D3715

2- deburr

3- assemble as per dwg D3713 and weld as per QSI004

J.J.L. 08/02/14

PL 08.02.14

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL 08/02/14

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PL 08.02.14

8.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 17.8500 sf(s)/Unit Total : 17.8500 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty Part Number

Description

Batch

17sq.ft M304EX0.75-16F

Expanded Metal

M107036

PL 08.02.15

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh to fit inside basket base and sides

2- weld mesh as per dwg D3712

PL 08.02.15

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

US 08.02.15
ENGINEERING
APPROVAL

PL 08.02.16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08.02.16	12S	WING WALK TOP OF LID PER QSI WOS 4.4	M-L	08/02/16	1	UP 08.02.16 pw QSI 642	1/	
08.02.16	12	POWDER COAT BLACK SANDTEX (4.3.5.7) PER QSI WOS 4.3	M-L	08/02/16	1	UP 08.02.16 pw QSI 642	1/08.02.26	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/02/2008 10:00:11 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 37287

Part Number: D3713041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AD 08-02-16

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

BLACK SANDTEX (4.3.5.7)

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 100700
08.02.16

M/L 08/02/16

(1X)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 08-02-19. ①

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF 08-02-19. ①

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.02.19

POSITIVE RECALL

EFFECTIVE 08.02.07 AUTH LA

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

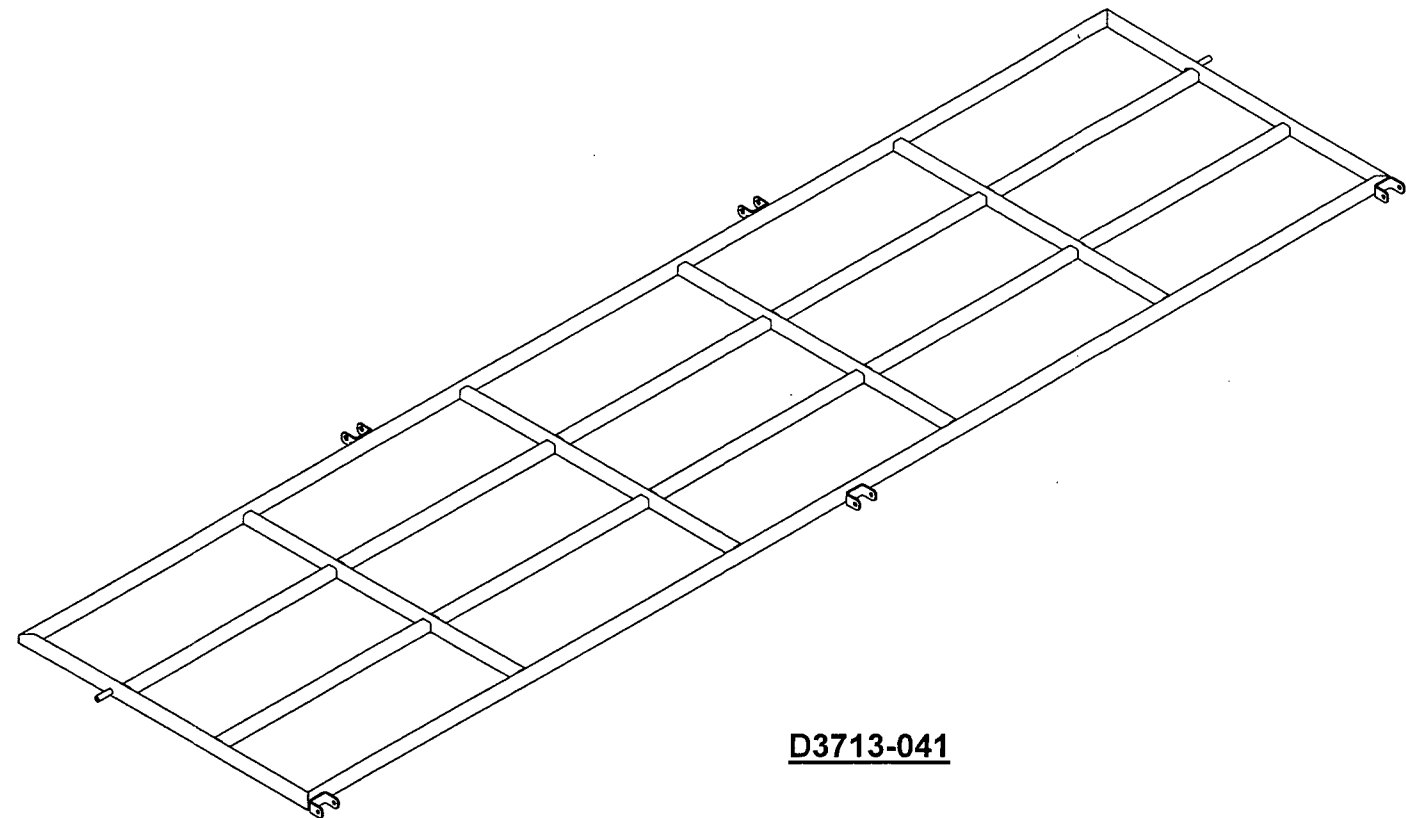
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY.	PART NUMBER	DESCRIPTION
X	D3713-041	LID ASSY LOW PROFILE BASKET
2	D2327-1	SPACER
2	D2581	MOUNTING BRACKET
2	D3714-1	RIB
2	D3715-1	RIB
10	D3716-1	RIB
4	D3732-1	RIB
1	D3743-1	MESH
3	D3749-1	HINGE HALF

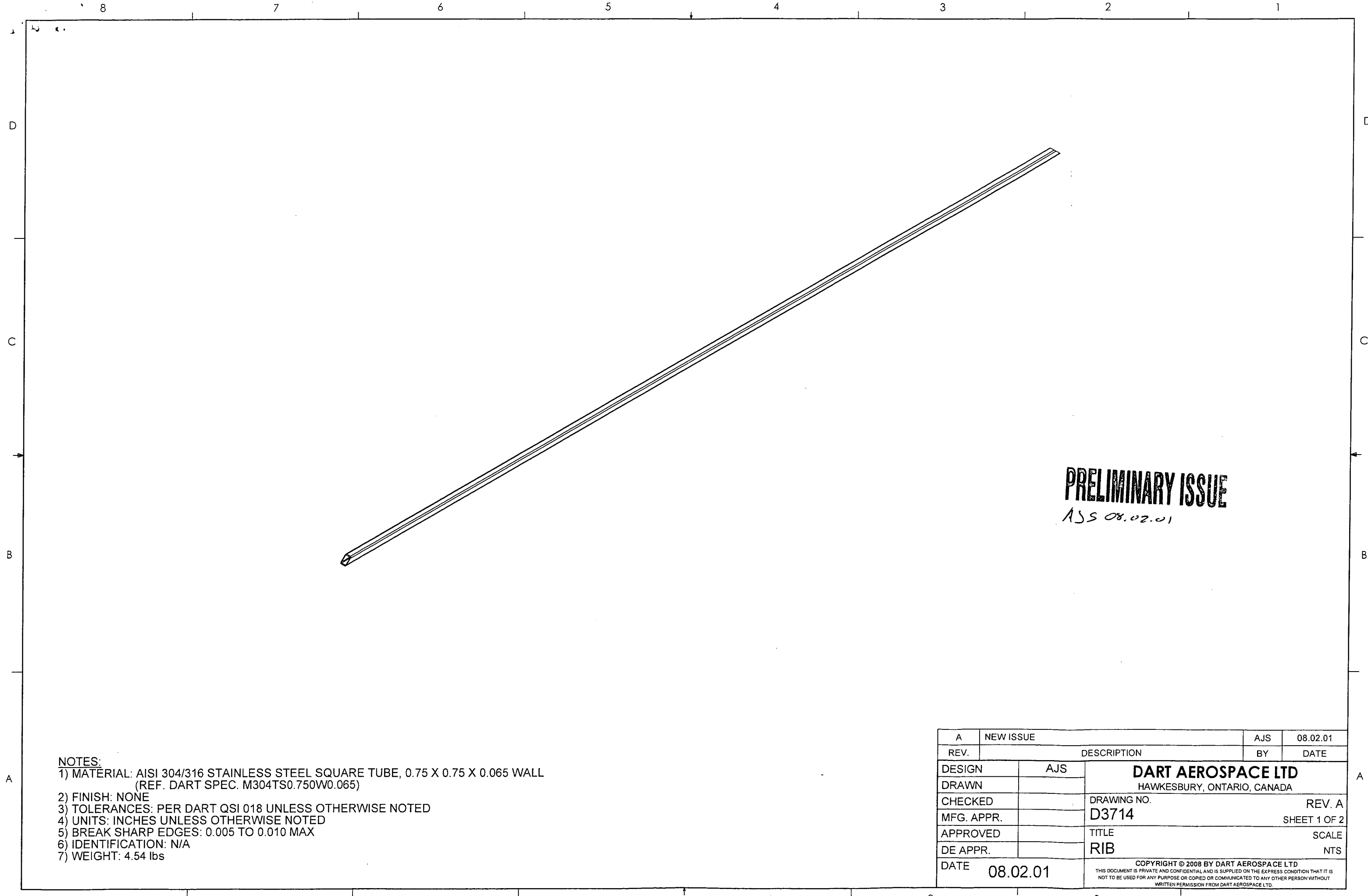
PRELIMINARY ISSUE
AJS 08.02.01



D3713-041

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3713-041 USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 26.09 lbs
 - 8) WELDING: PER DART QSI 004

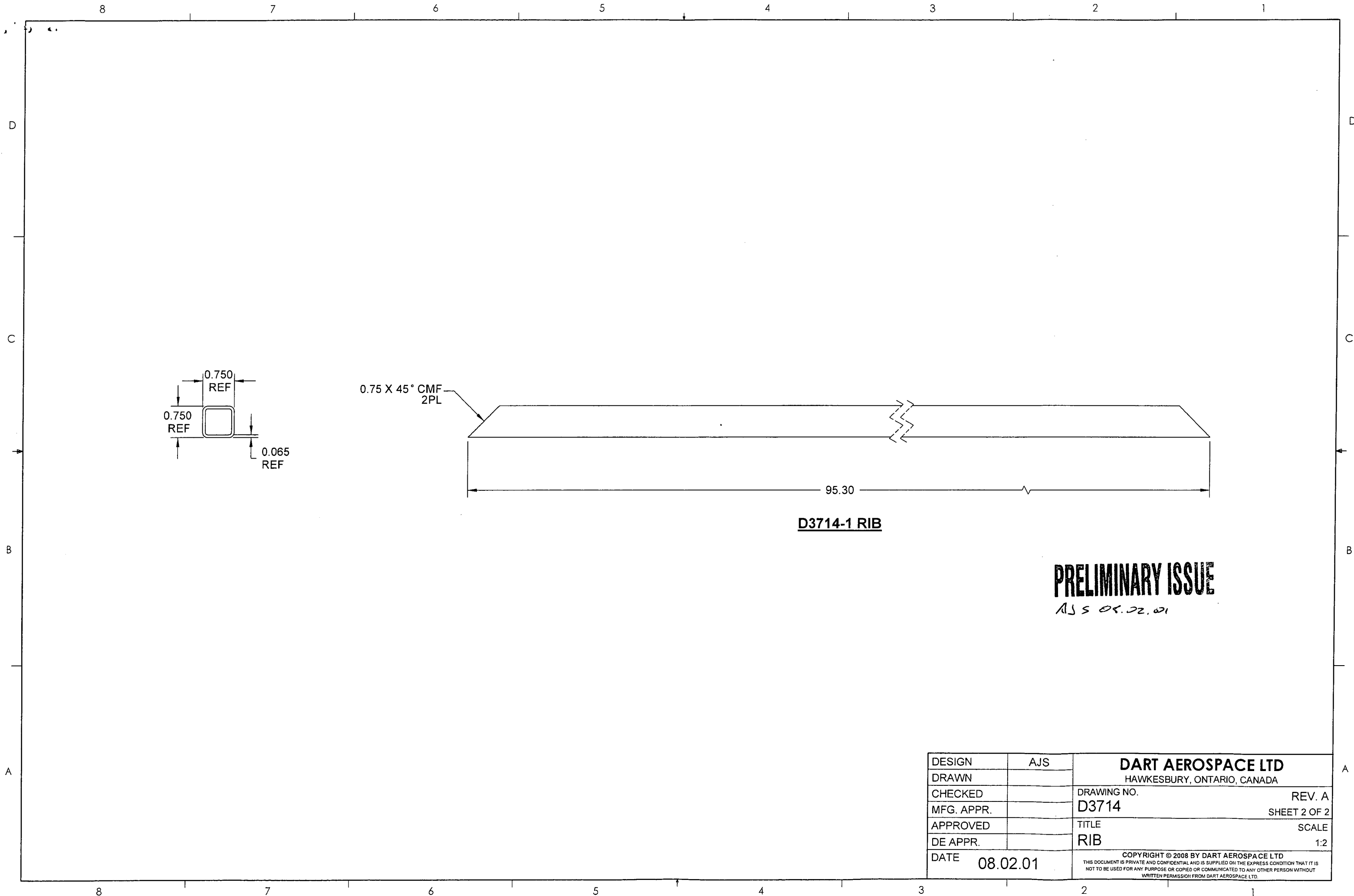
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DESIGN	AJS	DART AEROSPACE LTD	
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MFG. APPR.		D3713	SHEET 1 OF 1
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ASS 08.02.01

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
(REF. DART SPEC. M304TS0.750W0.065)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.54 lbs

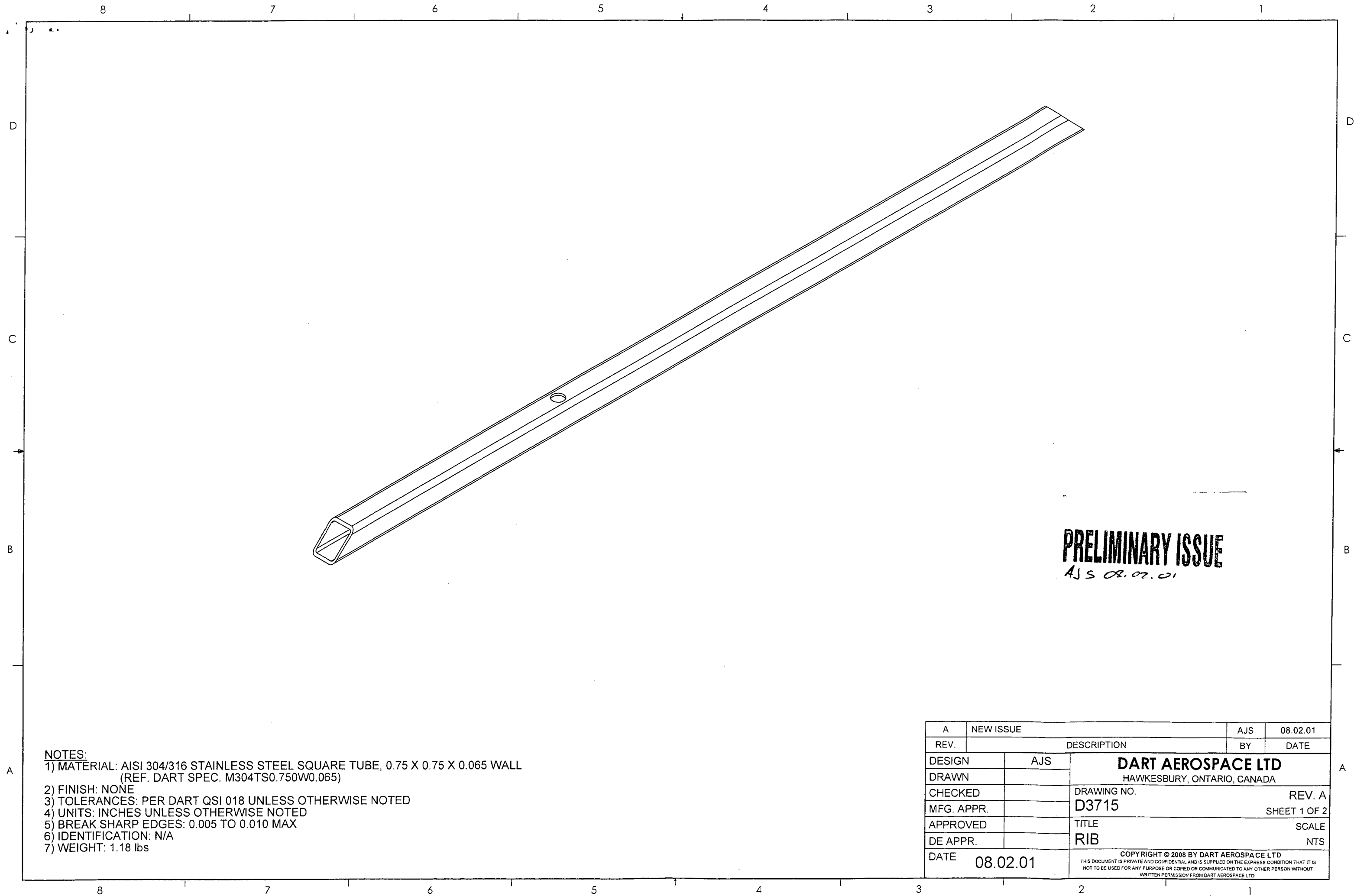
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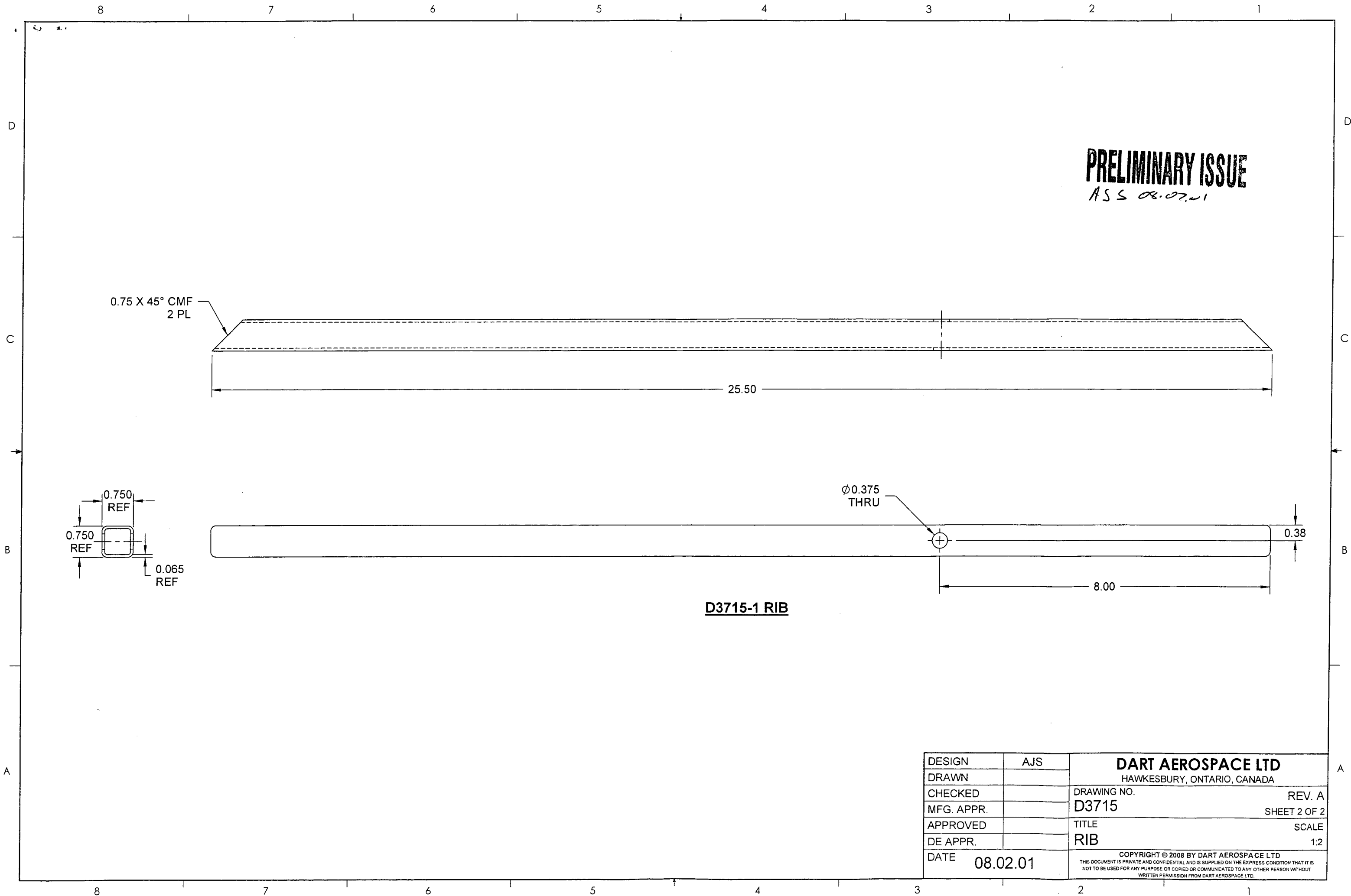
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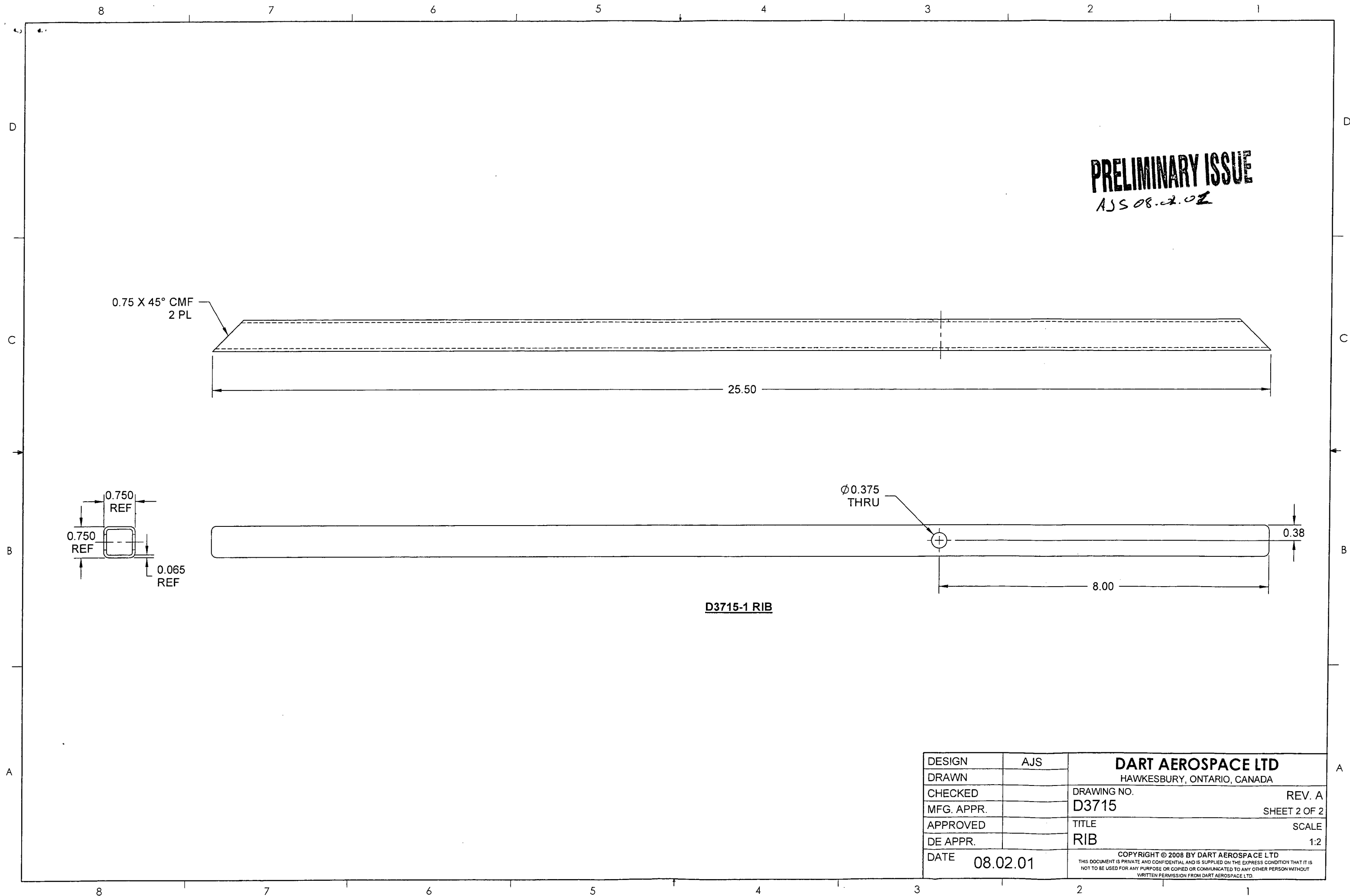
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL (REF. DART SPEC. M304TS0.750W0.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.18 lbs

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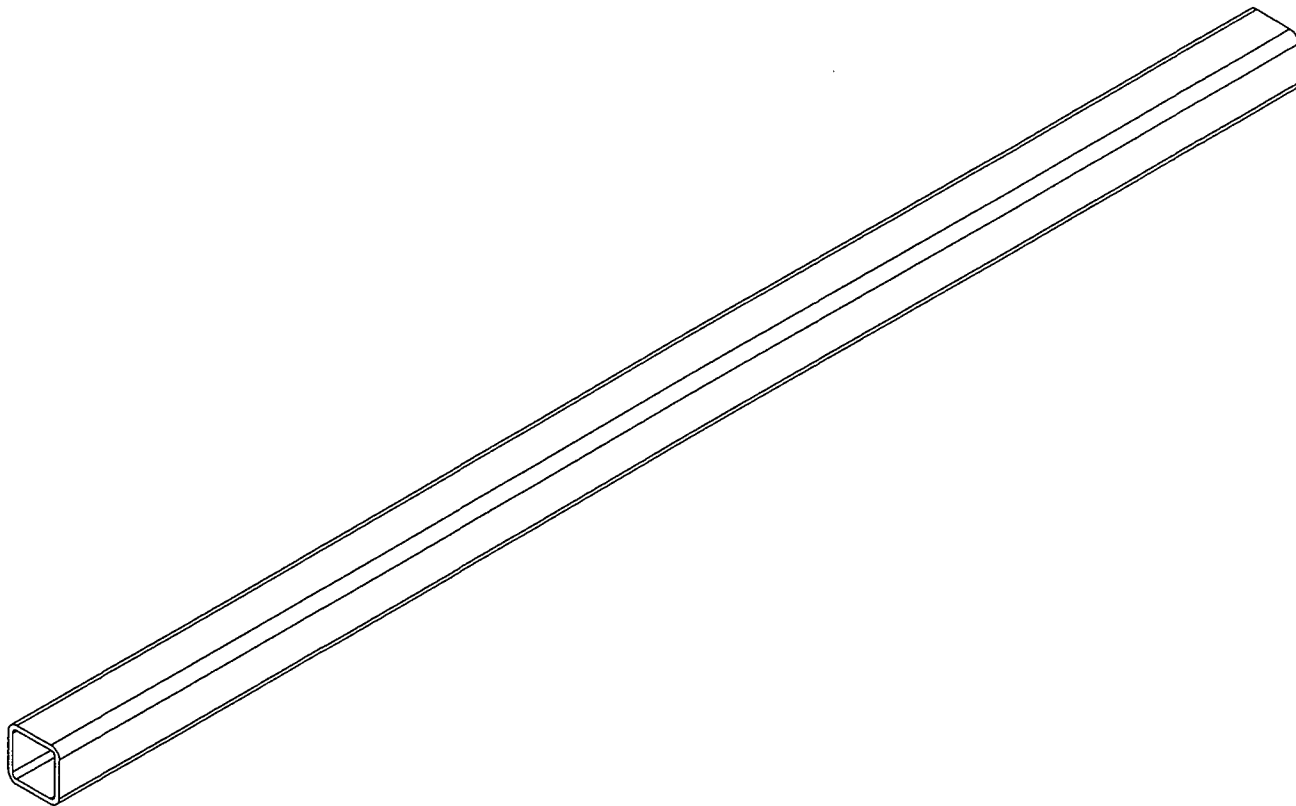
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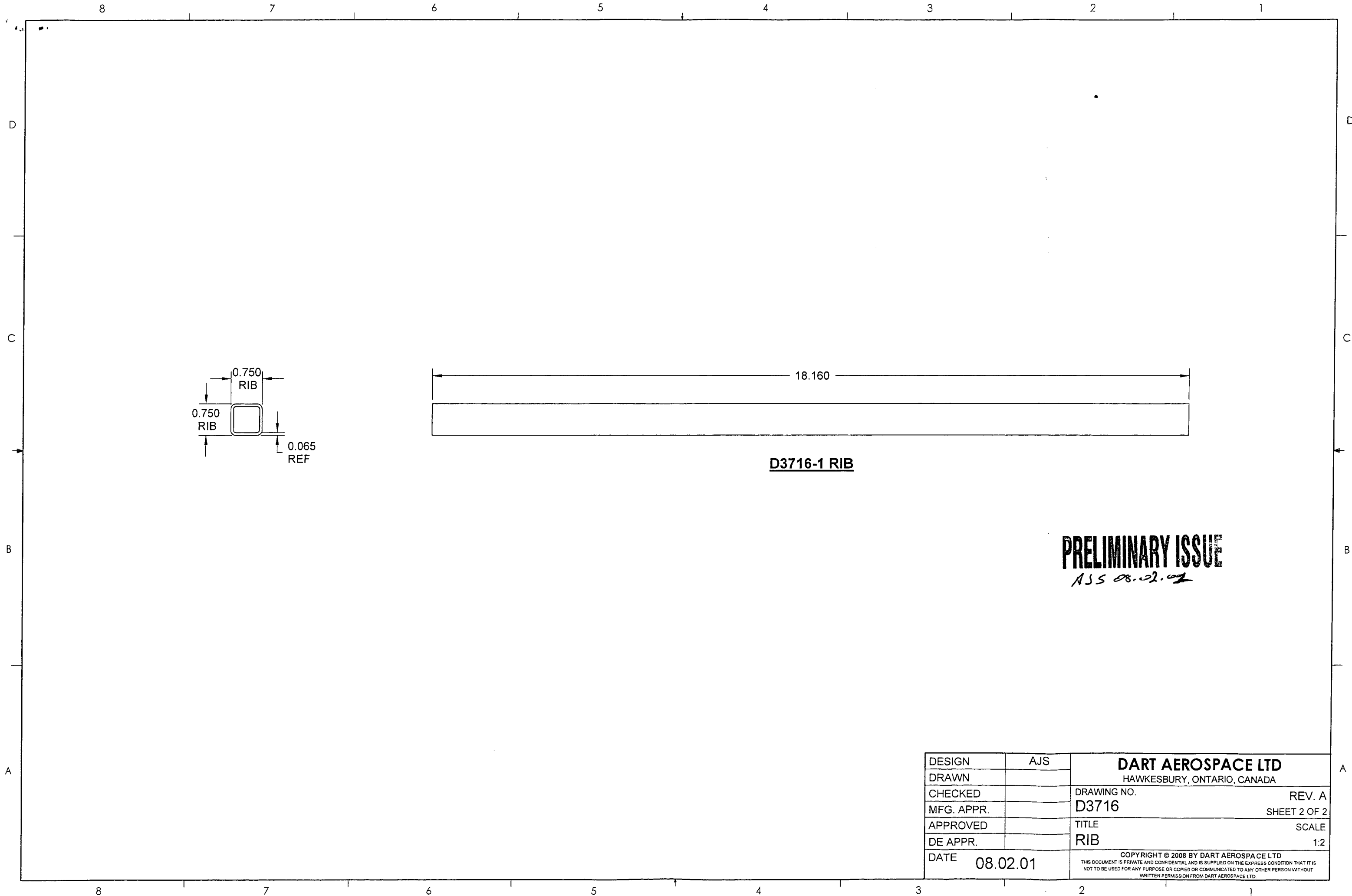


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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
(REF. DART SPEC. M304TS0.750W0.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.87 lbs

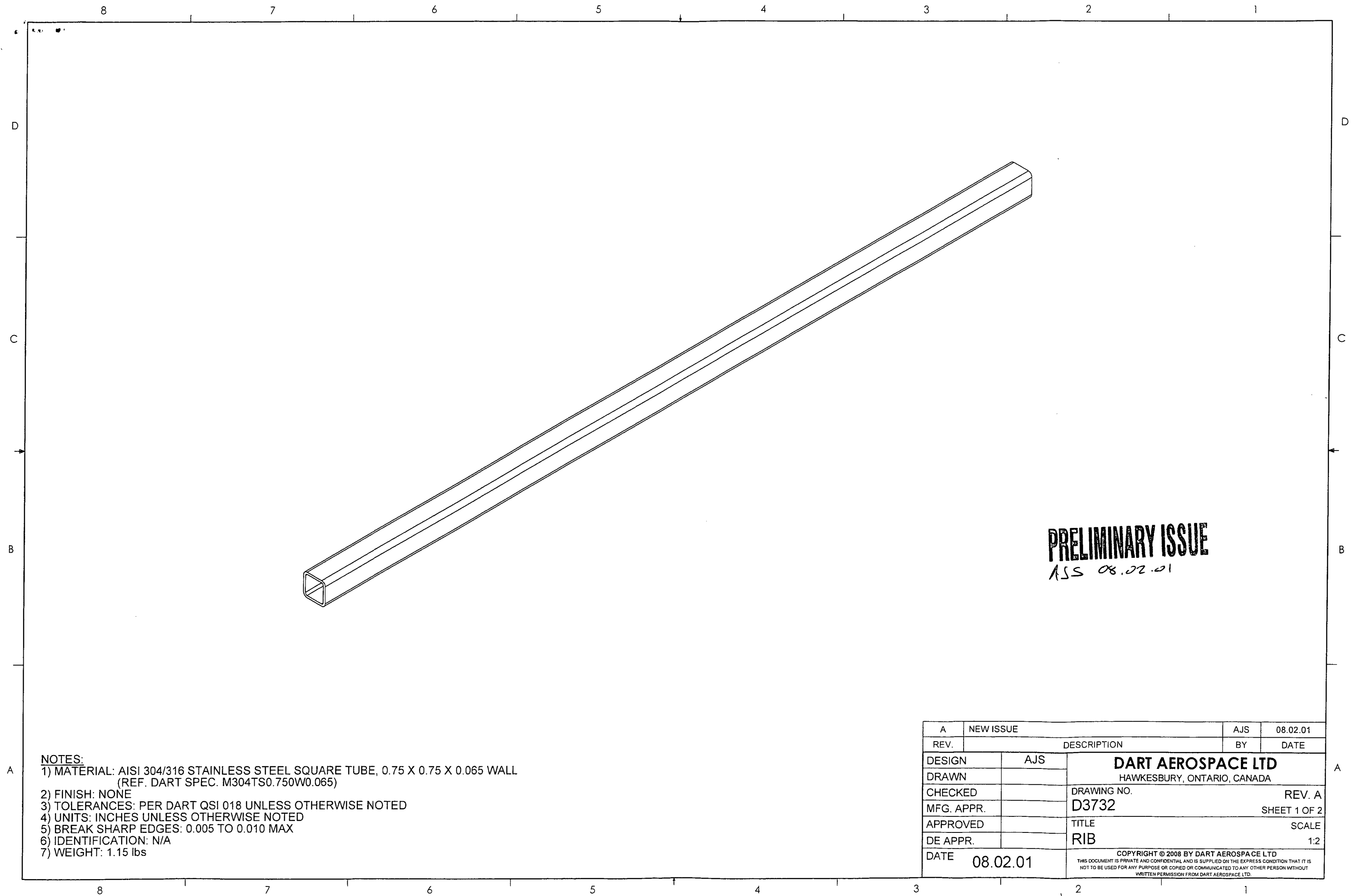
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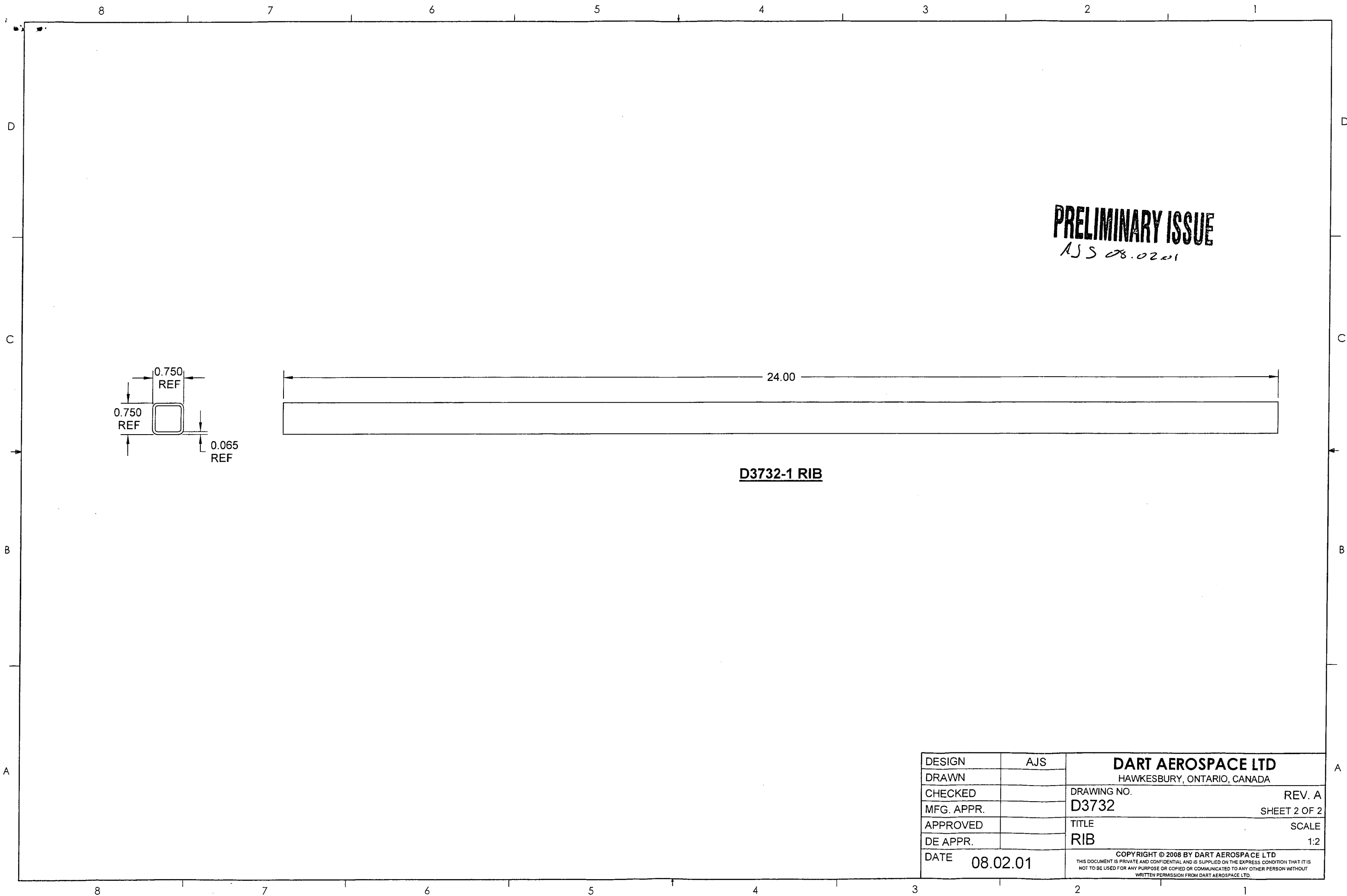
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL (REF. DART SPEC. M304TS0.750W0.065)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.15 lbs

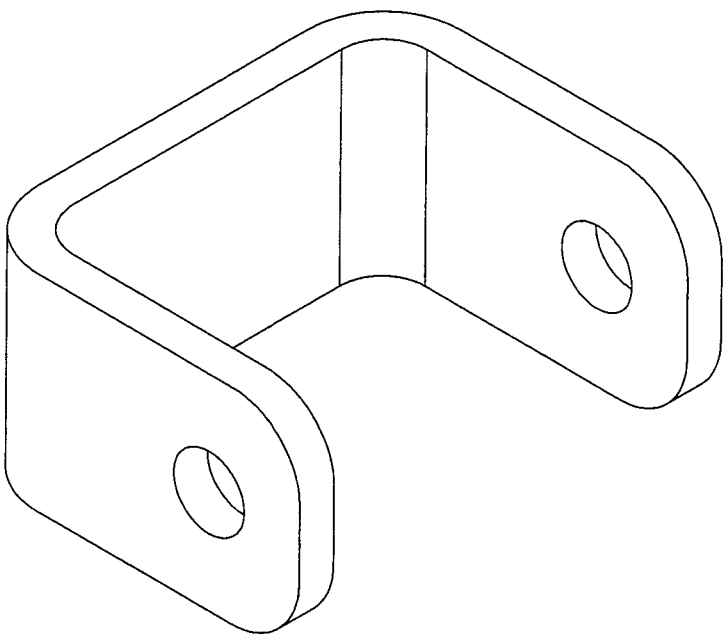
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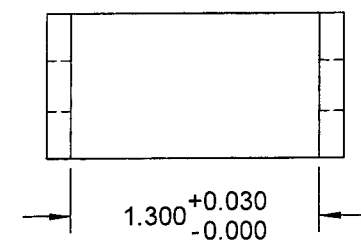
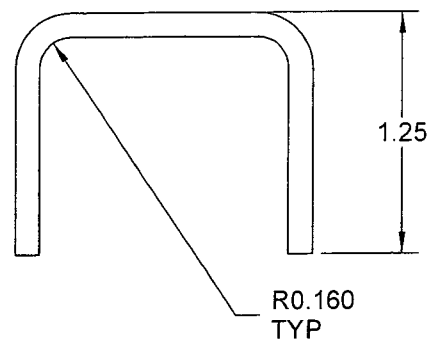


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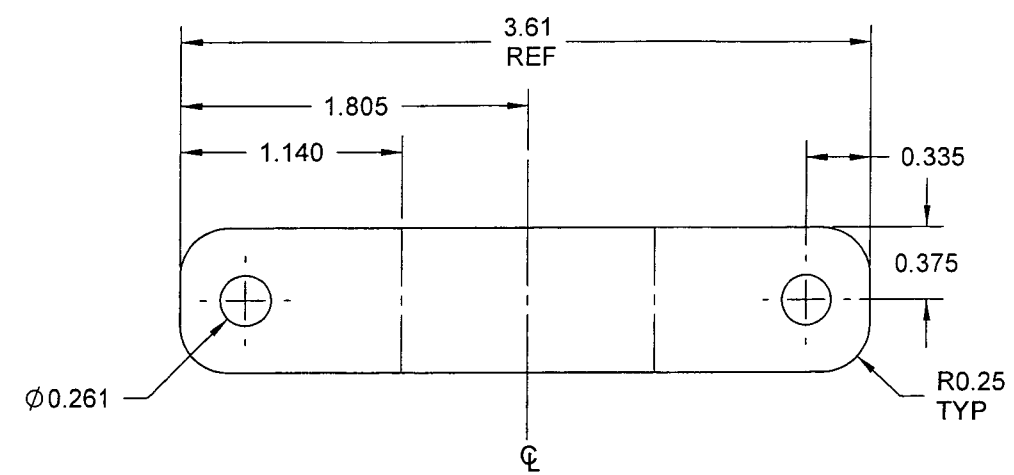
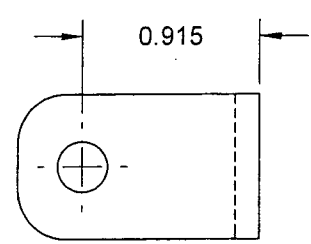
ASS 08.02.01

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC M304S11GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.09 lbs

A	NEW ISSUE		AJS	08.02.01
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DRAWN				
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MFG. APPR.		D3749		SHEET 1 OF 2
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D3749-1 HINGE HALF



D3749-1F FLAT PATTERN

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